

Date: Tuesday, 24/06/2008 1:24:52 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: D-PAD BASE
Job Number	: 40037		
Estimate Number	: 13388		
P.O. Number	:	Part Number	: PB6743001193
This Issue	: 24/06/2008 S.O. No. :	Drawing Number	: B67-43001 P.25
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 01/07/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>mf 08-06-24</u>		
Comment	: est rev A new issue 08.06.19 EC verified: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0116 sf(s)/Unit Total: 0.4620 sf(s)
 6061-T6 .125Sheet 106634 B 8-8-7
 batch: ~~10544~~ B 8-6-24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg
 Dwg Rev: B1
 Prog Rev: B1

B 8-8-7
 B 8-6-24

(59)

08/07/08

(54) Hum

2-Deburr if necessary

B 8-6

08/06/25

(54) Hum

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/06/25 (54)

5.0	MS21075L3	Nutplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)
 Nutplate
 batch: ~~1425505~~ 991

M108757 (88X)

M108560 (30X)

08/06/08

14107279 (88X)

08/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: D-PAD BASE

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

~~CCR2745533~~

Cherry Rivet



~~CCR264553~~

08.08.08

MS20426 AD 3-4



(PTU)

Comment: Qty.: 4.0000 Each(s)/Unit Total: 400.0000 Each(s)

Cherry Rivet

batch"

~~MS20426~~

216

08/08/08

08/07/10

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(PD)

Comment: SMALL & MEDIUM FAB RESOURCE 1

c'sink as per dwg.

Install nutplate with rivet.

08/08/08 (59)

~~08/07/10~~ (37)

8.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

08/08/08 (X55)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: NA

Pat E.

08.08.08

59

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/08

MF 08.08.08

Job Completion



~~CCR264553~~

~~MS20426~~

W/O: 40037		Est # 13388		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	# 6.0	Perment change CLR 264553 Rev 4 to the correct CLR 264553 B# _____ AS per Dwg.						<i>[Signature]</i> 080710	<i>[Signature]</i> 080710

Part No: PB6743001193 PAR #: SHA Fault Category: Production Engineering NCR: Yes No DQA: D Date: 08/08/08
CO-ordinator. QA: N/C Closed: D Date: 08/08/08

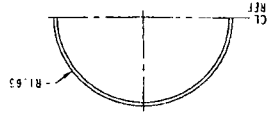
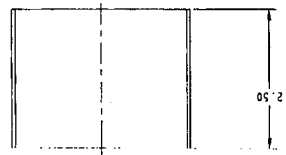
NCR: 40037		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080710	6.0	The incorrect rivets were listed on the w/o in accordance to the dwg.	[Signature] 080710	Retrain Employee to relate part to drawing work instructions. Always check	[Signature] 0808/10	[Signature] 08/07/10	[Signature]	[Signature]
	7.0	Production installed the incorrect rivets on top of e's sunk holes.		remove all incorrect rivets.				
		R. c! Lack of Attention, and verification by both parties. Production Engineering co-ordinating.	[Signature] 080710	Inspect hole condition a/c. See Bottom box.	SCRAP [Signature] 08/08/08	[Signature] 08/07/10	[Signature]	[Signature] 080710
				rework A> per dwg	[Signature] 08/08/08	[Signature] 08/07/10	[Signature]	[Signature] 080710
			[Signature] 080710	All holes are ovalized and not accurate. Scrap and destroy Qty 159 and replace B# 106634	[Signature] 080710	[Signature] 08/07/10	[Signature] 080710	[Signature] 08/07/10

NOTE: Date & initial all entries

ORIGINAL

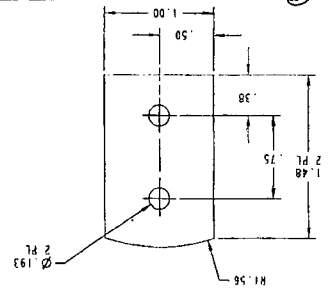
PREMIER AVIATION, INC.
3000 Aviation Parkway, Grand Prairie, Texas 75052
PART NO. B67-43001
REV. 01
DATE: 01/08/81

③ -189 D-PAD FACE
MATERIAL: .063 THK, 6061-T6, 00-A-250/11
SCALE: 1.000

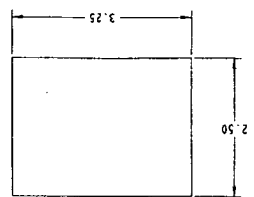


#40037

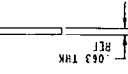
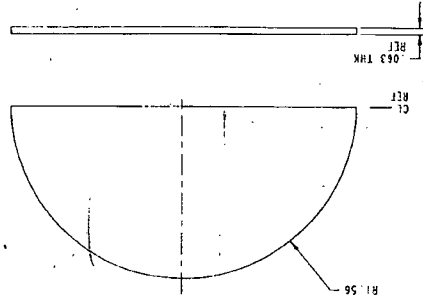
④ -193 D-PAD BASE
MATERIAL: .125 THK, 6061-T6, 00-A-250/11
SCALE: 2.000



⑤ -185 D-PAD BACK PLATE
MATERIAL: .063 THK, 6061-T6, 00-A-250/11
SCALE: 1.000



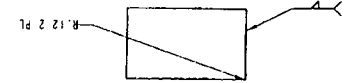
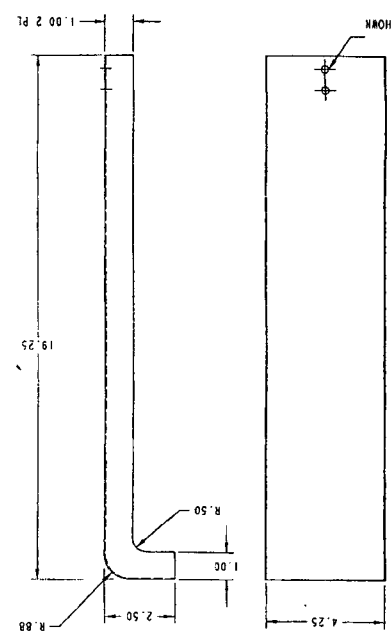
⑥ -339 D-PAD TOP
MATERIAL: .063 THK, 6061-T6, 00-A-250/11
SCALE: 2.000



REFERENCE ONLY

REFERENCE ONLY

⑦ -69 90 DEGREE COVER PLATE
MATERIAL: .032 THK, 6061-T6, 00-A-250/11
SCALE: 0.500

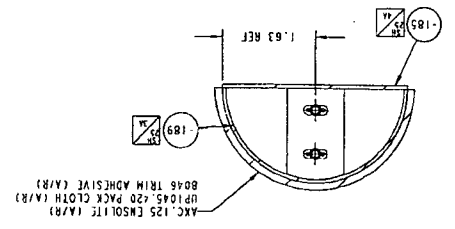
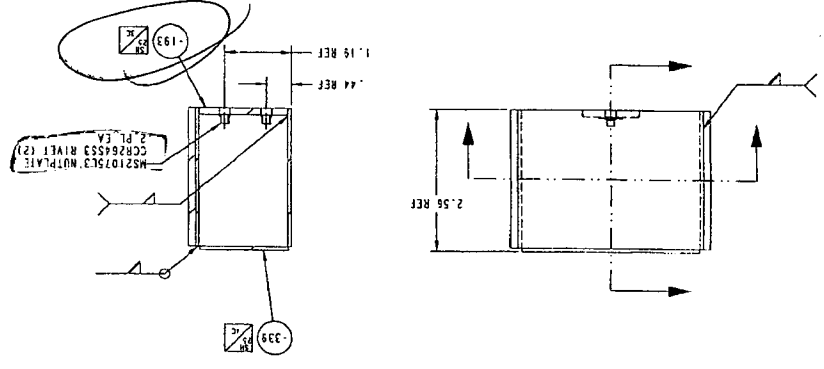


LOCATE HOLE AT
INSTALLATION. SHOWN
HERE FOR REF
(2 PLACES)

RELEASED

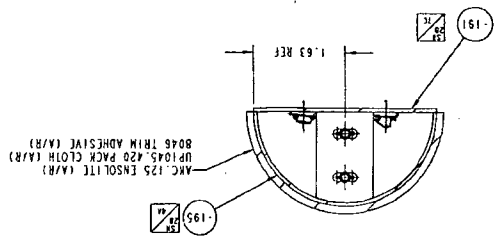
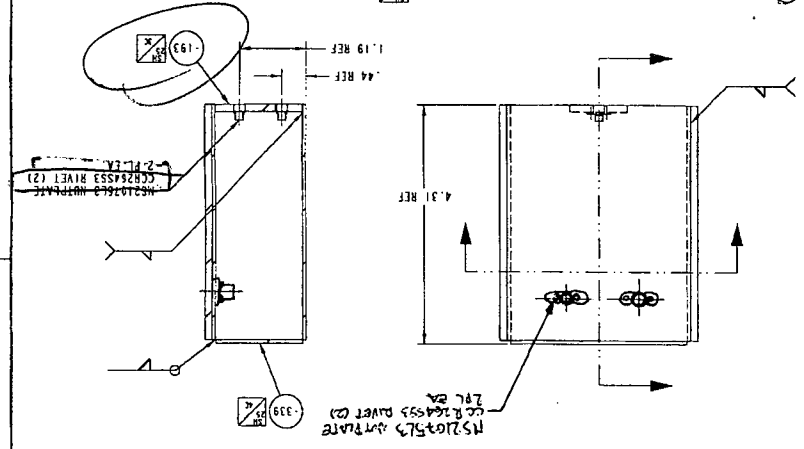
⑥ -83 SHORT D-PAD ASSEMBLY

SCALE 1.000



⑦ -85 LONG D-PAD ASSEMBLY

SCALE 1.000



PREMIER AVIATION, INC.
2001 AVIATION PARKWAY, CHANDLER, ARIZONA 85226
DISHV8 B67-43001
REV. 12/85

RELEASED

